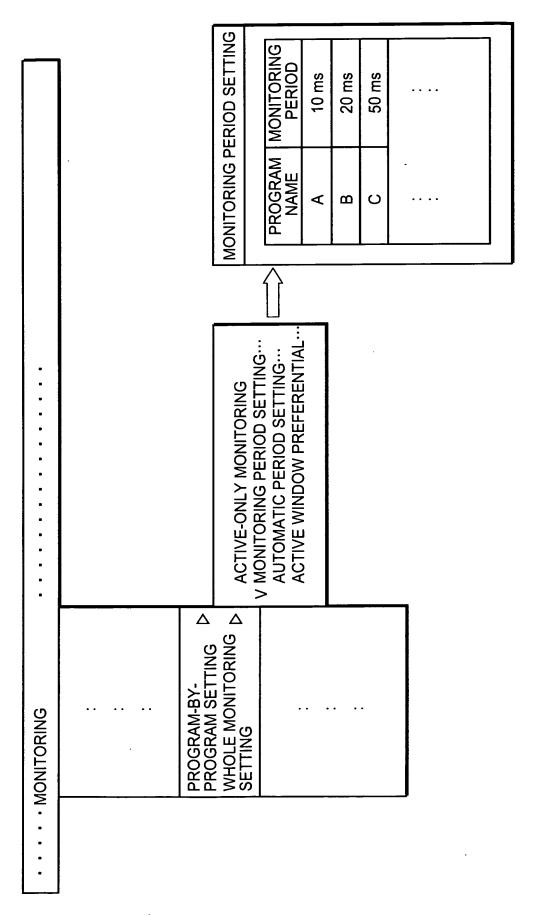


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Title: Peripheral Device Of M

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I. SETTING STATE

SETTING STATE

02:MONITORING PERIOD SETTING 03:AUTOMATIC PERIOD SETTING 04:ACTIVE WINDOW PREFERENTIAL 01:ACTIVE-ONLY MONITORING 00:ORDINARY MONITORING

II. PERIODS OF RESPECTIVE PROGRAM NAMES PERIOD [ms] PROGRAM NAME

FIG.5

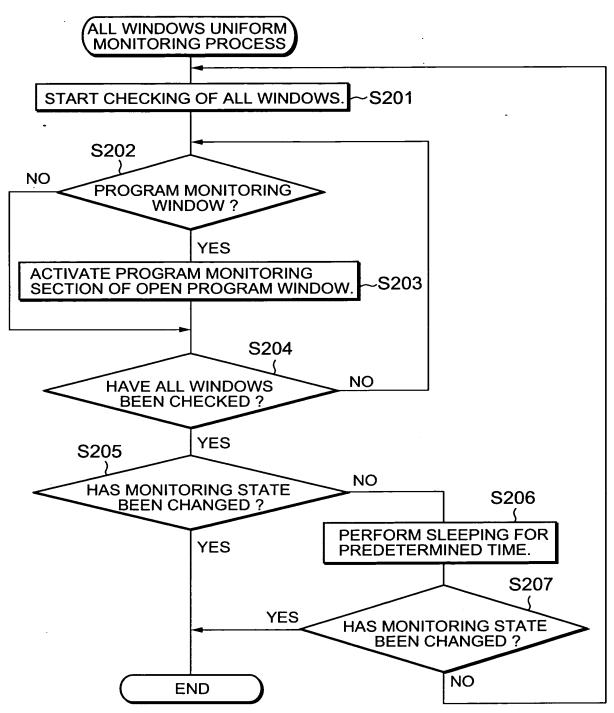
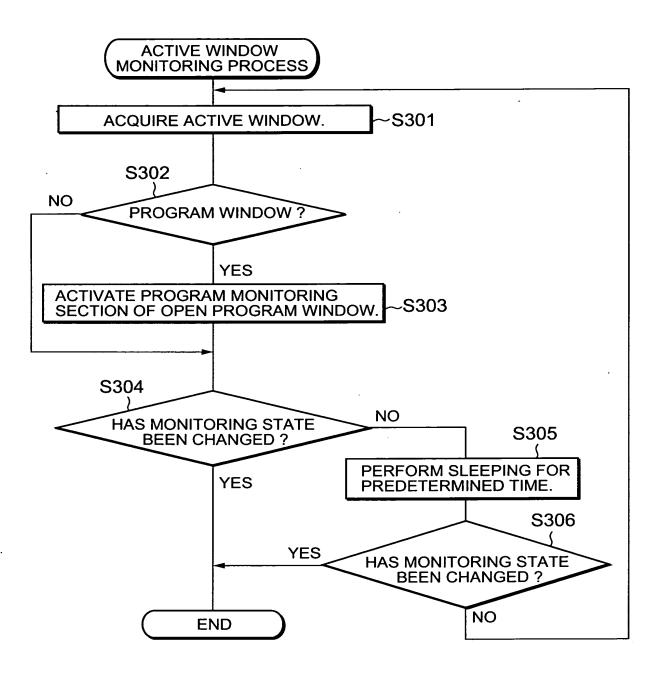
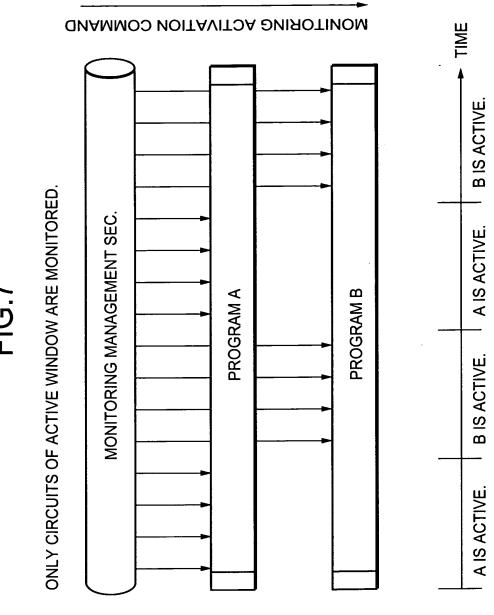
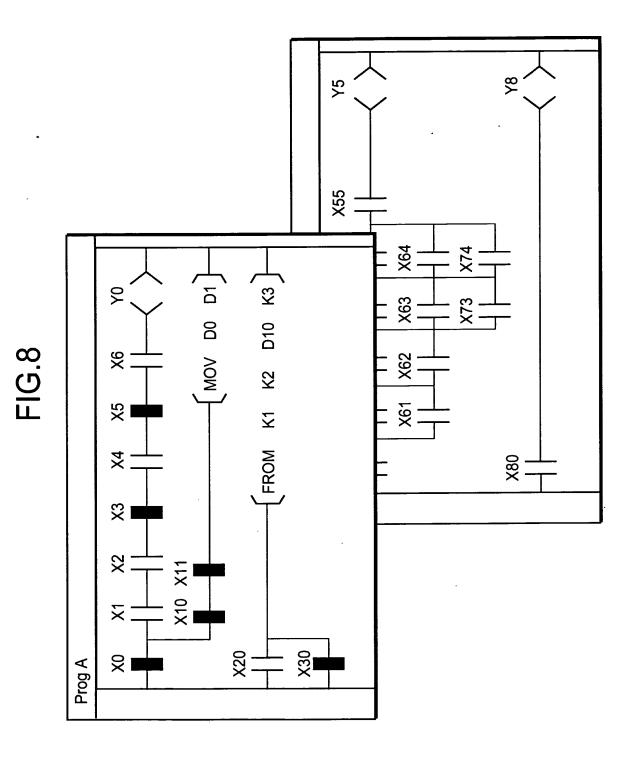
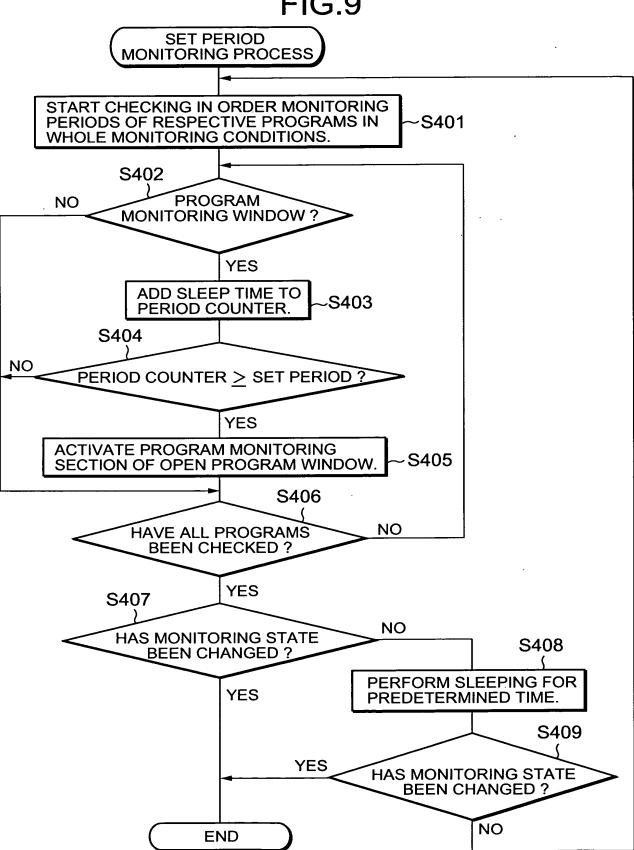


FIG.6









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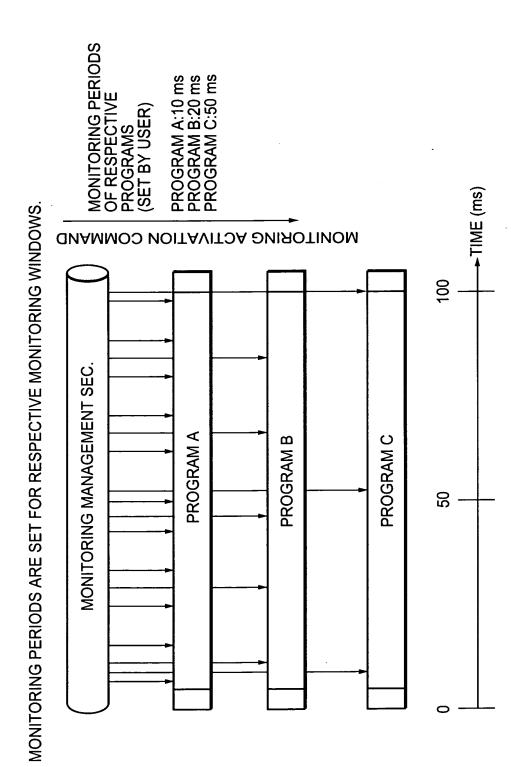
II. PERIODS OF RESPECTIVE PROGRAM NAMES

I. SETTING STATE

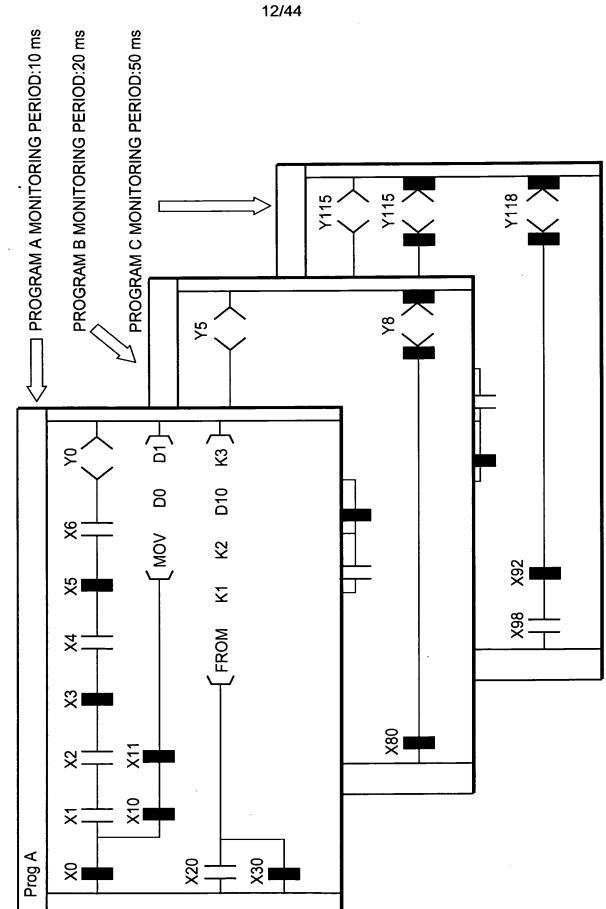
02

PERIOD [ms] 20 9 50 PROGRAM NAME A $\mathbf{\omega}$

> 02:MONITORING PERIOD SETTING 03:AUTOMATIC PERIOD SETTING 04:ACTIVE WINDOW PREFERENTIAL 01:ACTIVE-ONLY MONITORING 00:ORDINARY MONITORING

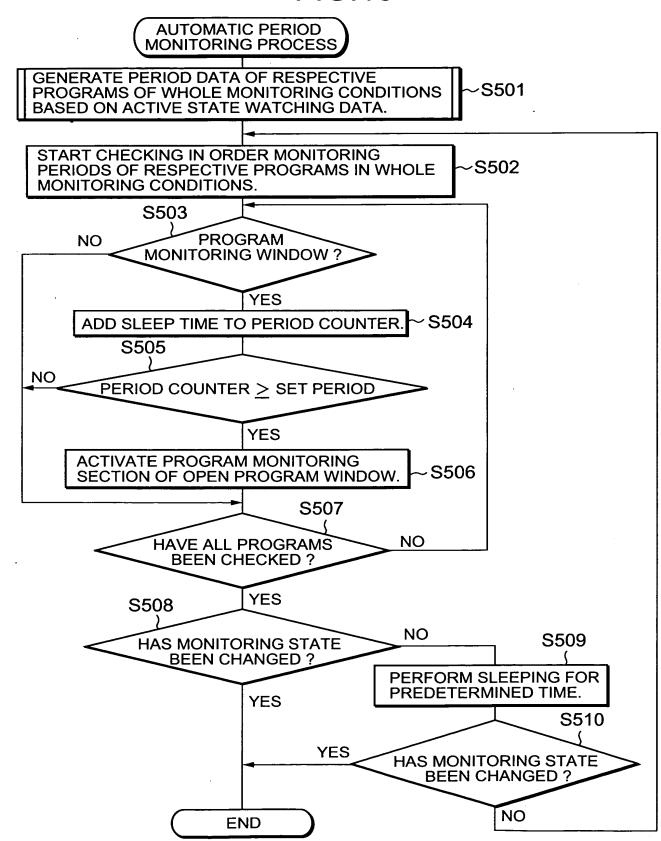


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Title: Peripheral Device Of A Programmable Controller And Monitoring Method Of Said Peripheral Device

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FIG.14

AUTOMATIC PERIOD SETTING TY MONITORING SETTING	PE
REFERENCE MONITORING PERIOD	TIME
10	

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FIG.15

EXAMPLE OF DATA OF TOTAL MONITORING CONDITIONS IN AUTOMATIC PERIOD SETTING TYPE MONITORING

I. SETTING STATE

03

00:ORDINARY MONITORING

01:ACTIVE-ONLY MONITORING

02:MONITORING PERIOD SETTING

03:AUTOMATIC PERIOD SETTING

04:ACTIVE WINDOW PREFERENTIAL

II. PERIODS OF RESPECTIVE PROGRAM NAMES

PROGRAM NAME	PERIOD [ms]
Α	10
В	20
С	50

III. REFERENCE MONITORING PERIOD TIME

10 ms

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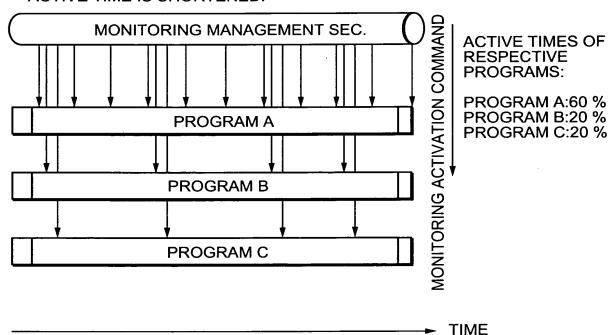
FIG.16

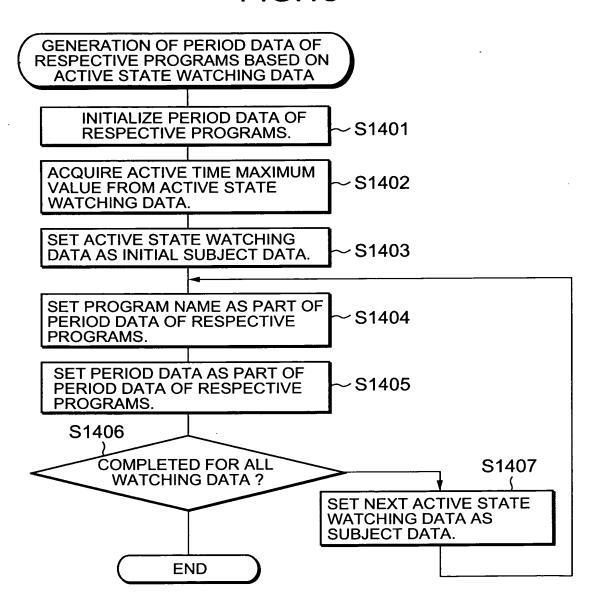
STATE OF ACTIVE STATE WATCHING DATA

PROGRAM NAME	ACTIVE TIME	PRESENCE CONFIRMATION FLAG
А	60	1
. В	20	1
С	20	1

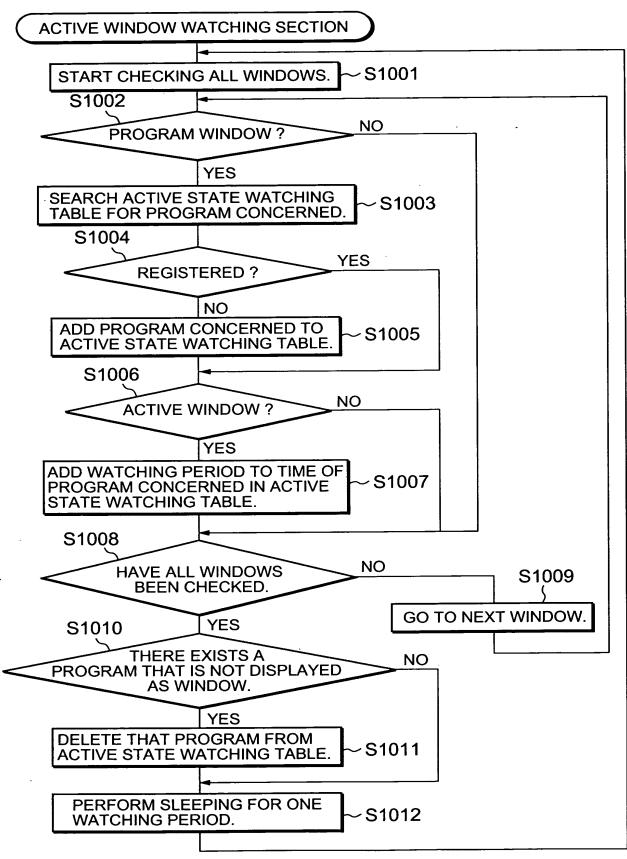
FIG.17

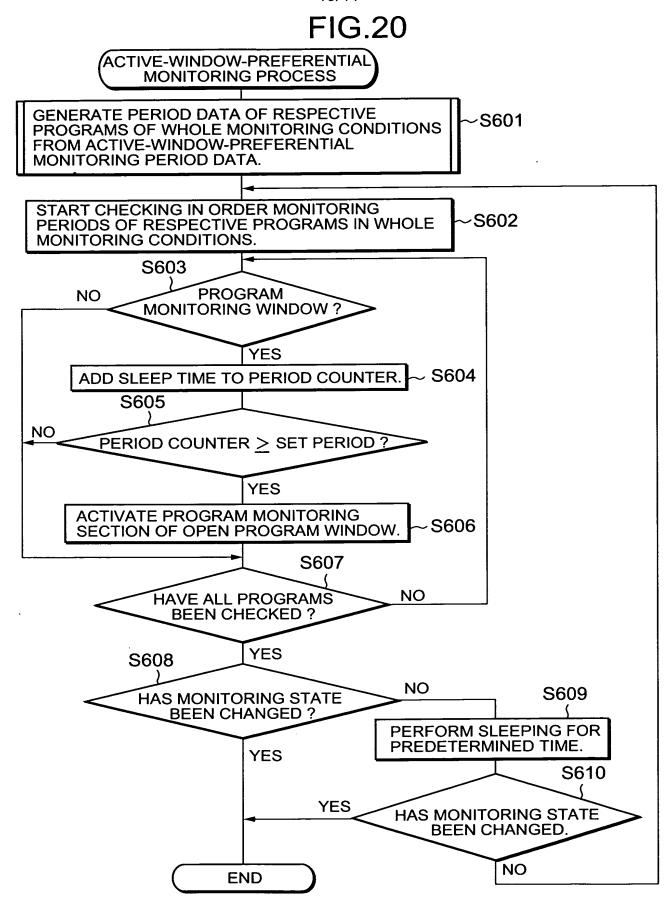
MONITORING PERIOD OF WINDOW HAVING LONGER ACTIVE TIME IS SHORTENED.





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ACTIVE-WINDOW-PREFERENTIAL SETTING			
ACTIVE WINDOW MONITORING PERIOD TIME [ms]			
	10		
INACTIVE WINDOW MONITORING PERIOD TIME [ms]			
	50		

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FIG.22

EXAMPLE OF DATA OF TOTAL MONITORING CONDITIONS IN ACTIVE-WINDOW-PREFERENTIAL MONITORING

I. SETTING STATE

04

00:ORDINARY MONITORING
01:ACTIVE-ONLY MONITORING
02:MONITORING PERIOD SETTING
03:AUTOMATIC PERIOD SETTING
04:ACTIVE WINDOW PREFERENTIAL

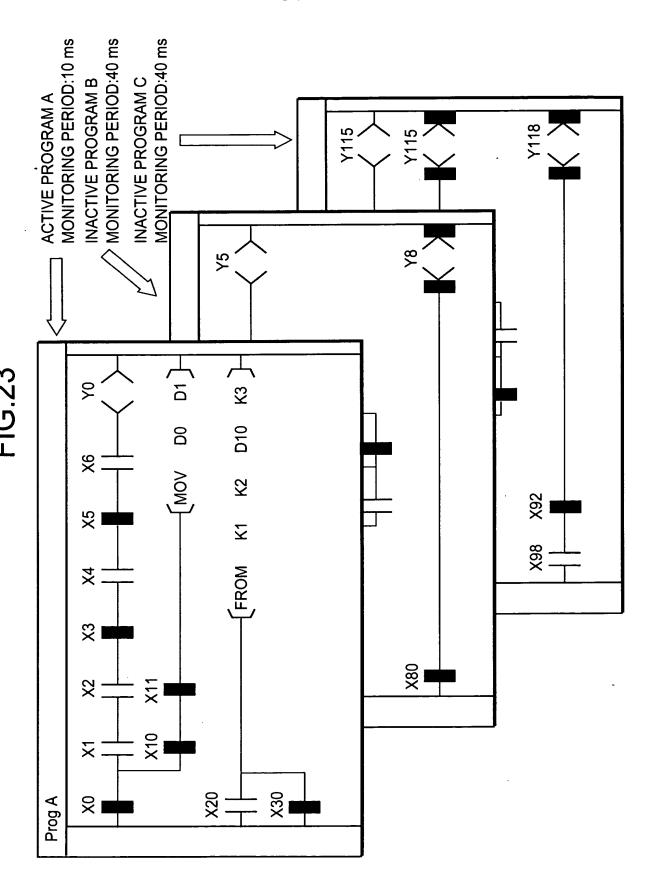
II. PERIODS OF RESPECTIVE PROGRAM NAMES

PROGRAM NAME	PERIOD [ms]
Α	10
В	50
С	50

III. ACTIVE-WINDOW-PREFERENTIAL MONITORING PERIODS

ACTIVE MONITORING TIME	IN ACTIVE MONITORING TIME
10	50

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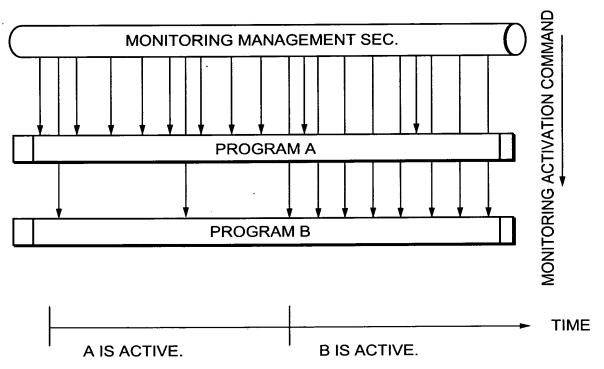


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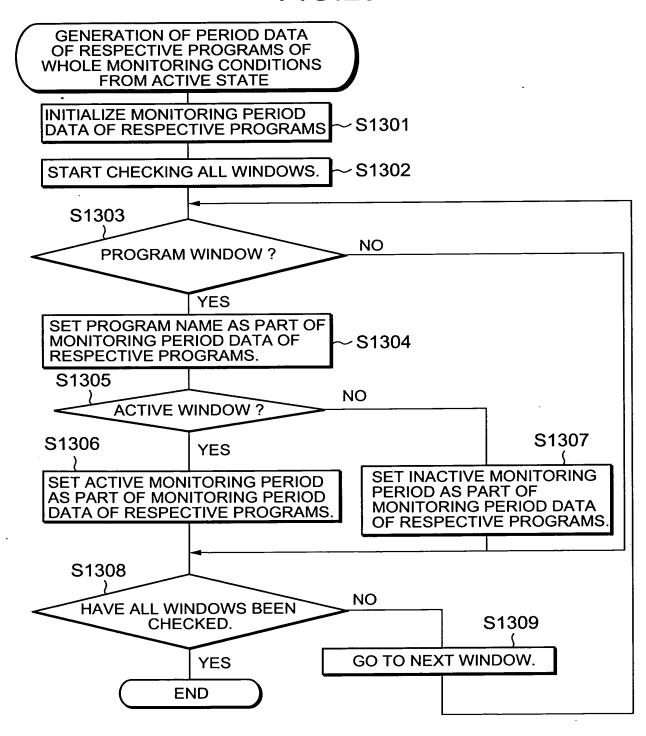
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FIG.24

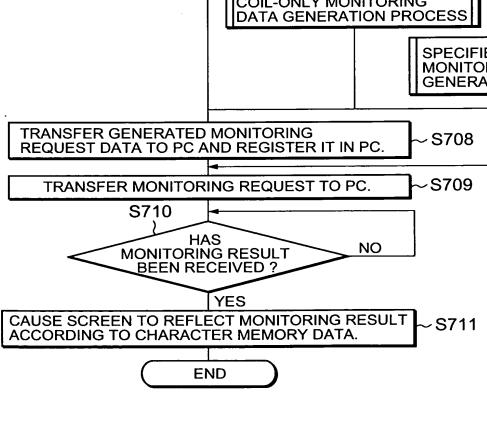
MONITORING PERIOD OF INACTIVE WINDOW IS MADE LONGER.



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Title: Peripheral Device Of A Programmable Controller And Monitoring Method Of Said Peripheral Device Inventors: ITABA et al. Atty Docket No.: 400925/MELCO Leydig, Voit & Mayer, Ltd. 202-737-6770 25/44 **FIG.26** PROGRAM MONITORING SECTION S701 HAS MONITORING NO REQUEST DATA NOT BEEN **S702 GENERATED?** HAS CHANGE YES OCCURRED IN CHARACTER YES MEMORY. NO **S703 HAS** NO MONITORING TYPE **BEEN CHANGED?** YES S704 MONITORING TYPE OF PROGRAM-BY-PROGRAM MONITORING DATA MONITORING IN **COIL-ONLY** SELECTED NO MONITORING CONDITION **REGION** MONITORING MONITORING DATA S706 **GENERATION PROCESS** S705 COIL-ONLY MONITORING S707 DATA GENERATION PROCESS SPECIFIED REGION MONITORING DATA **GENERATION PROCESS** TRANSFER GENERATED MONITORING ∽S708 REQUEST DATA TO PC AND REGISTER IT IN PC. TRANSFER MONITORING REQUEST TO PC. ∙S709 S710 **HAS** NO MONITORING RESULT



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V MONITORING ONLY IN SPECIFIED REGION. COIL-ONLY MONITORING Δ WHOLE MONITORING SETTING PROGRAM-BY-PROGRAM SETTING · · MONITORING

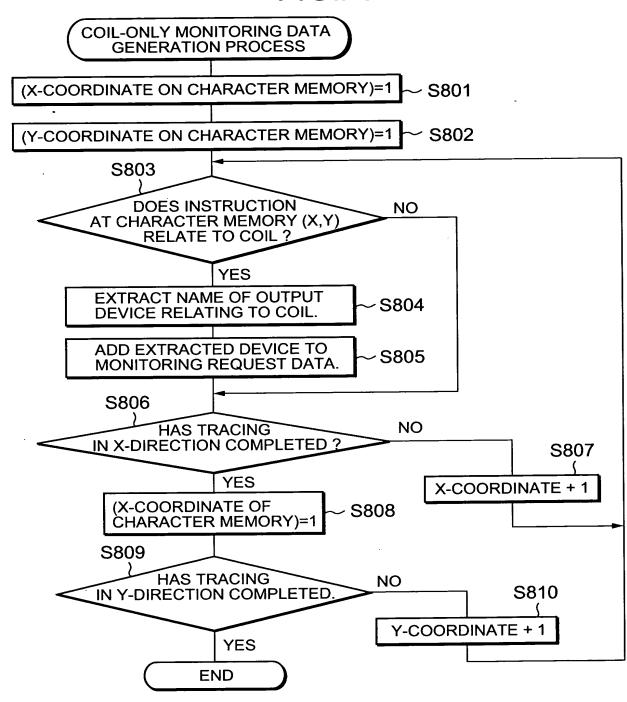
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FIG.28

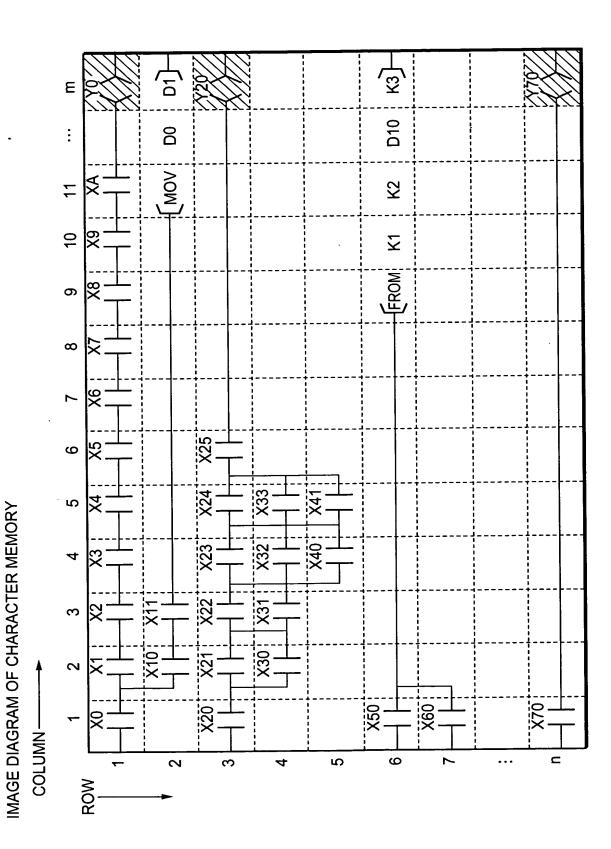
PROGRAM-BY-PROGRAM MONITORING DATA DIAGRAM

00:NO MONITORING CONDITION 01:COIL-ONLY MONITORING 02:MONITORING IN SELECTED REGION	02:SELECTED REGION OF MONITORING IN SELECTED REGION			
MONITORING TYPE	LEFT-END COORDINATE OF SELECTED REGION	TOP COORDINATE OF SELECTED REGION	RIGHT-END COORDINATE OF SELECTED REGION	BOTTOM COORDINATE OF SELECTED REGION

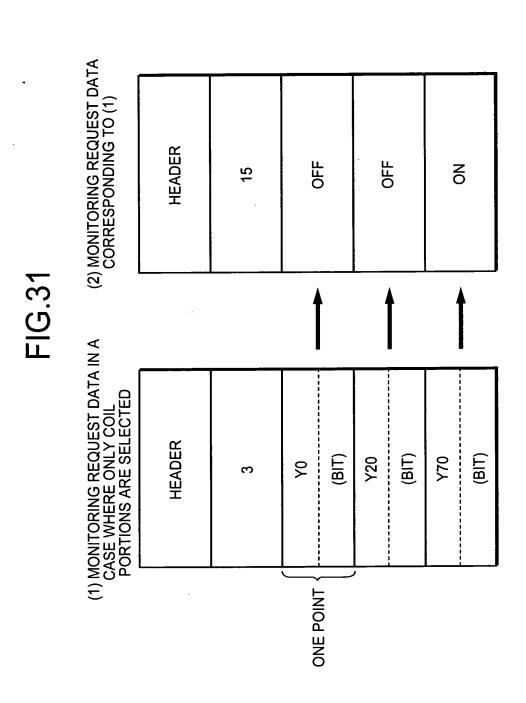
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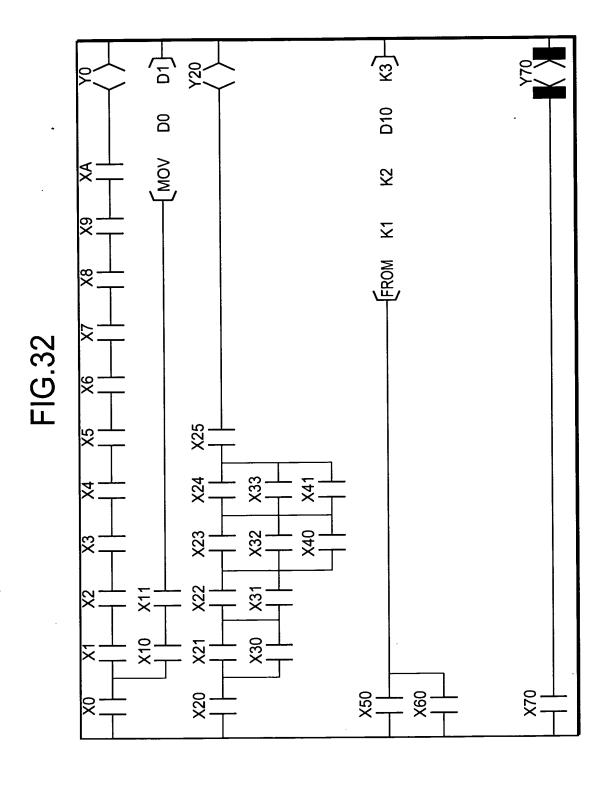


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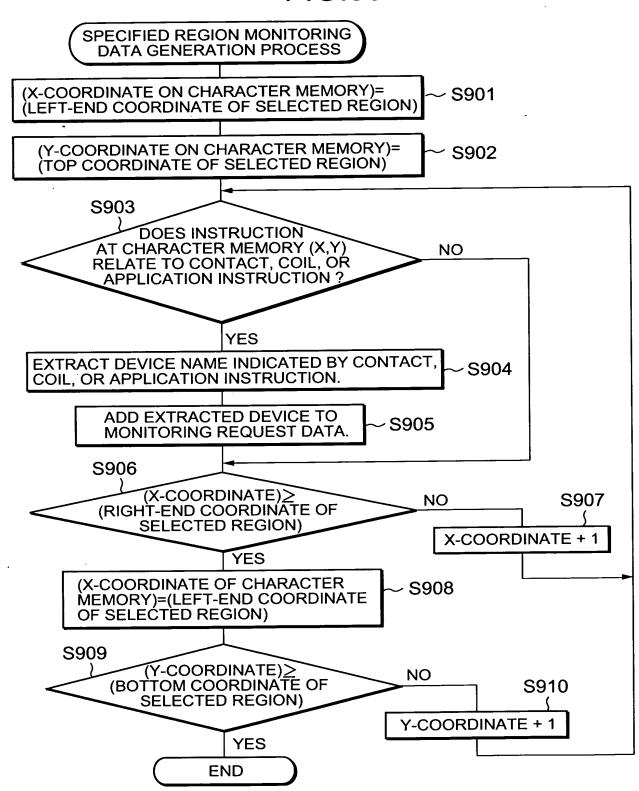


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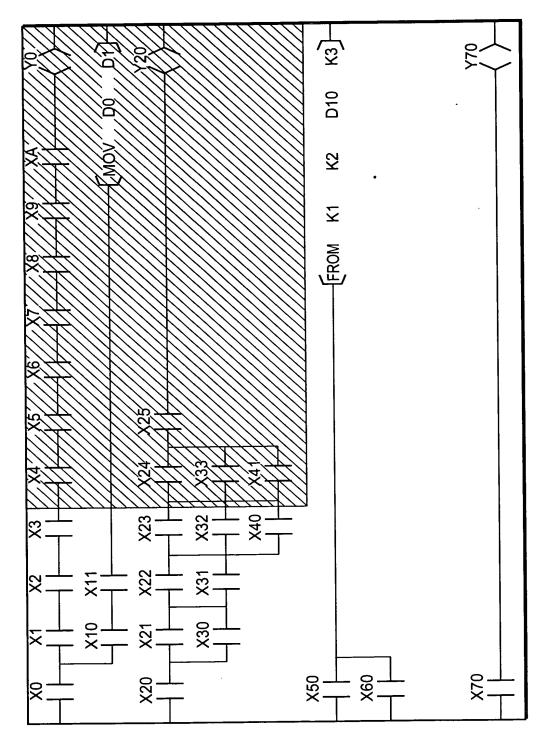
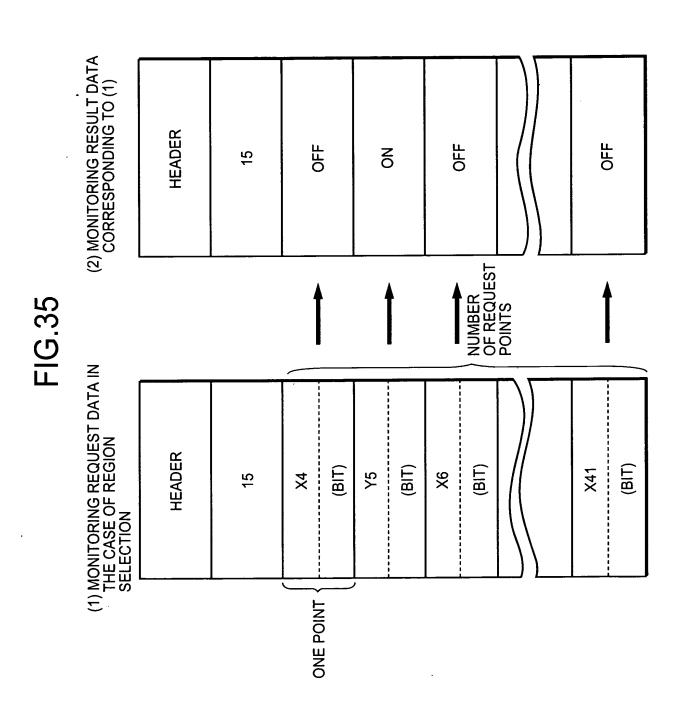
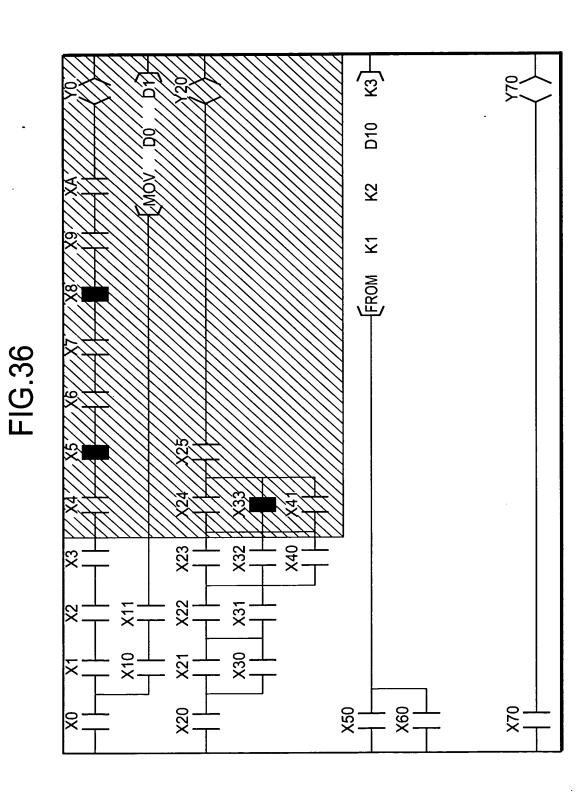


FIG.34

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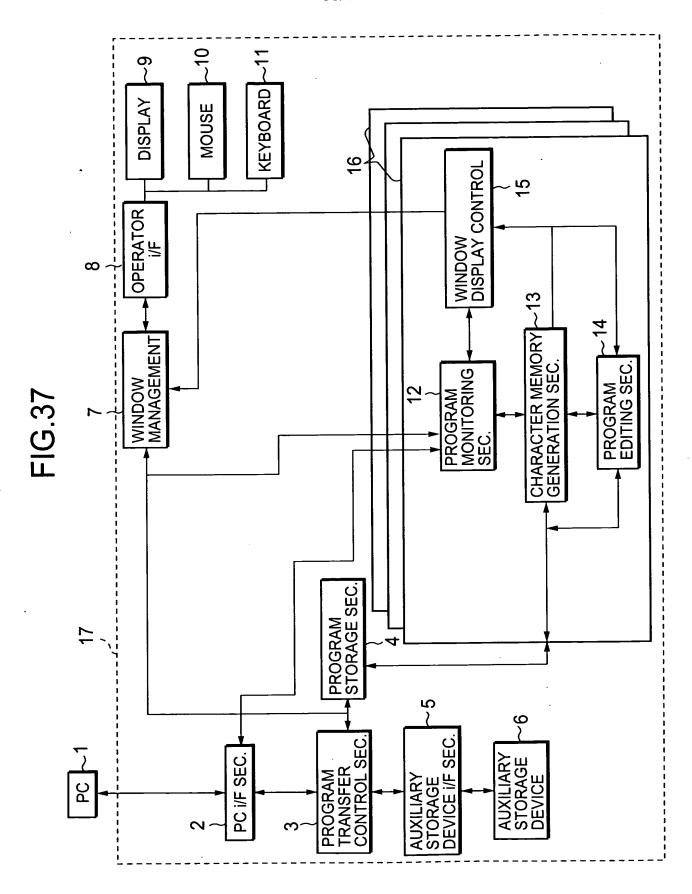


IMAGE DIAGRAM OF CHARACTER MEMORY

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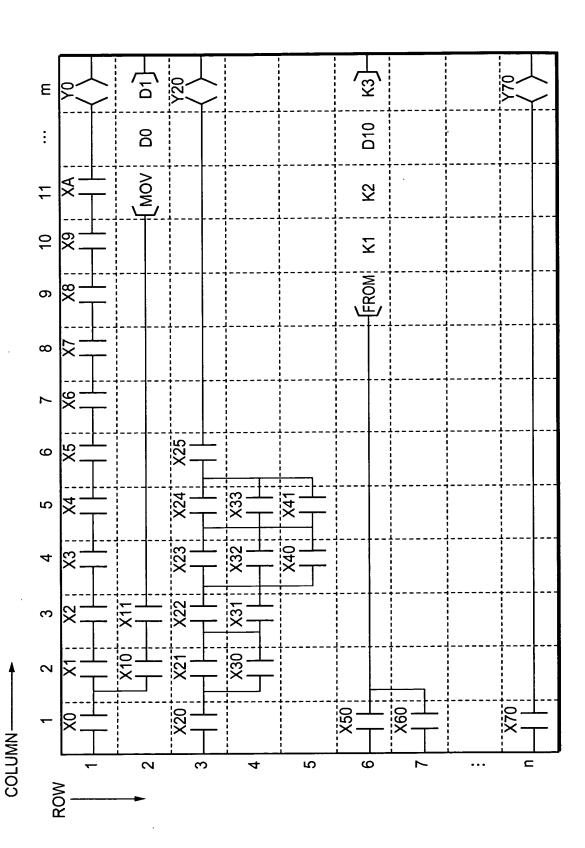
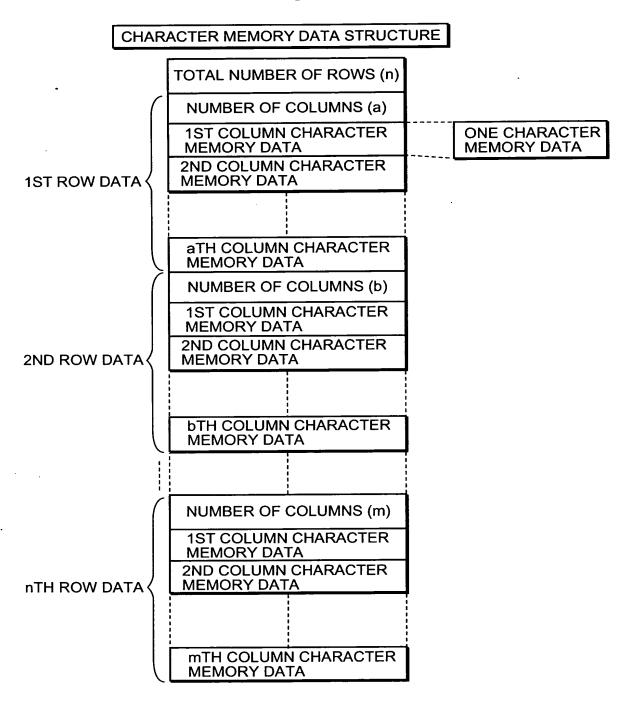


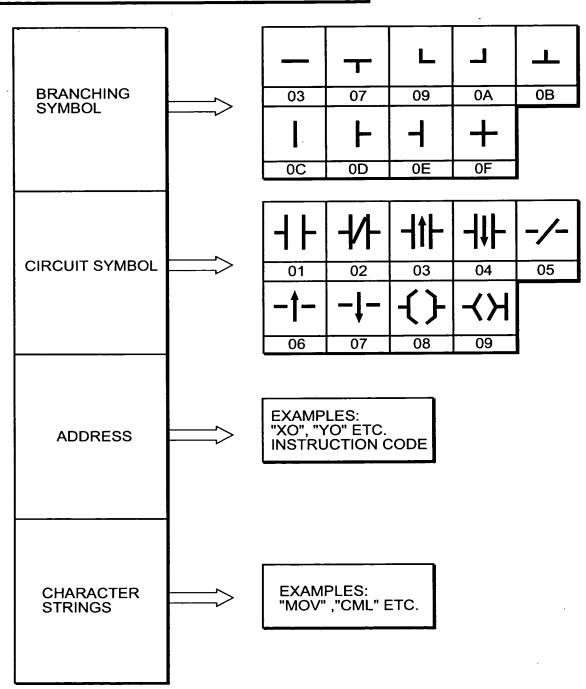
FIG.39



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FIG.40

ONE CHARACTER MEMORY DATA STRUCTURE





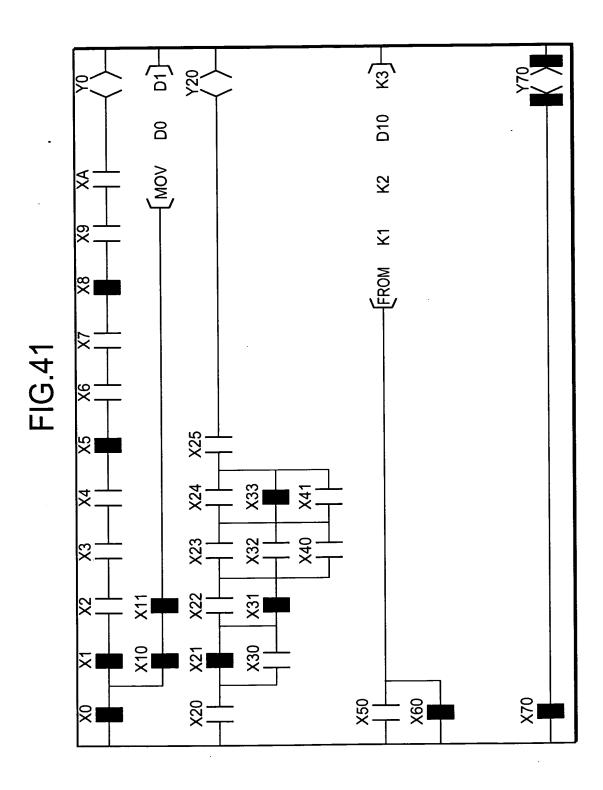
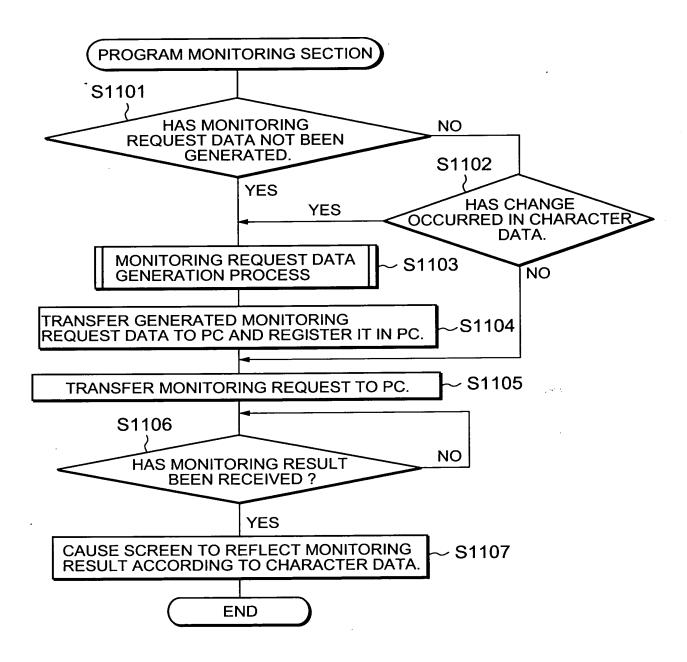
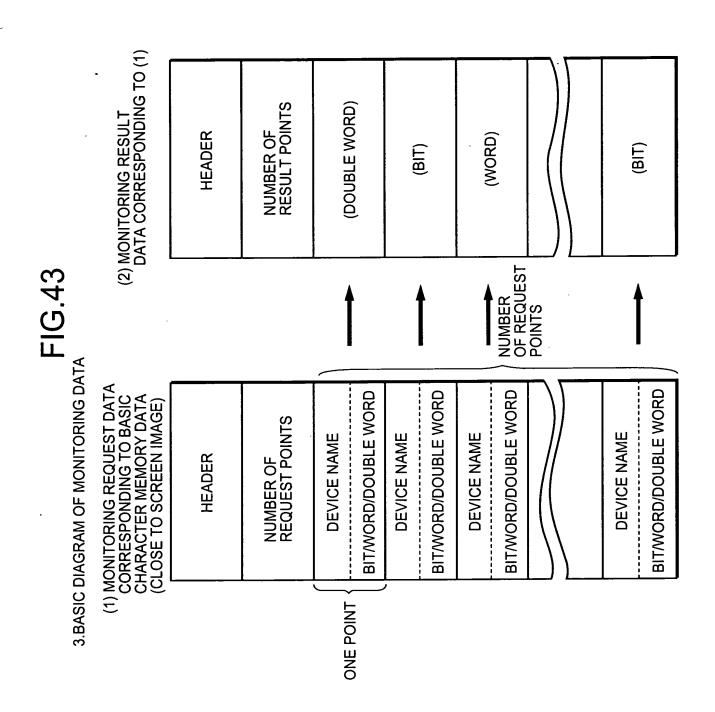




FIG.42





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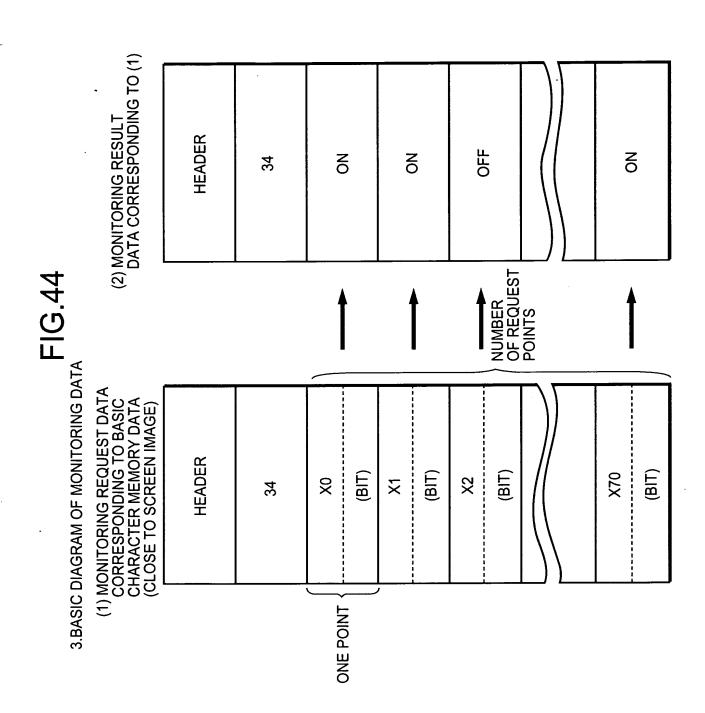




FIG.45

